



DereW 57171




# Work Order ID 45283

Wednesday, March 24, 2010 9:16:22 AM

Page 1

Item ID:	D3476-043	Accept		Setup	Start	
Revision ID:	B					
Item Name:	Blower Motor Adapter Weldment				Stop	
Start Date:	7/15/2009	Start Qty:	2.00		Cust Item ID:	
Required Date:	8/3/2009	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	<i>MP</i>	Date:	<i>10-3-24</i>	Tooling:	Date:	Run	Start	
	QC:		Date:		SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3476	Rev B								
100		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Spot Weld Tubes And Nut plates as per Dwg D3476 and Dart QSI 018								
	***** D3476-1 goes on top of D3476-3 *****								
110	QC11- Inspect spot weld per QSI004	0.00							
									
QC	Memo	0.00							
Quality Control									
120	QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo	0.00							
Quality Control									

✓

*8/10/03/13*

*S. Collier*

*(42)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 45283

Wednesday, March 24, 2010 9:16:23 AM



Page 2

Item ID: D3476-043

Accept



Setup Start



Revision ID: B

Stop



Item Name: Blower Motor Adapter Weldment

Start Date: 7/15/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: 1/19

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

5156

MF 10-3-04

10/03/30

MF

10-3-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 27/01/2009 11:11:58 AM  
 User: Julie Dawson

## Process Sheet

Split

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BLOWER MOTOR ADAPTER
Job Number	: 45283 -2	Part Number	: D3476043
Estimate Number	: 12133	Drawing Number	: D3476 UNDER REVIEW
P.O. Number	:	Project Number	: N/A
This Issue	: 27/01/2009 S.O. No. :	Drawing Revision	: A
Prsht Rev.	: NC	Material	:
First Issue	: 1/1 Type : SMALL /MED FAB	Due Date	: 15/02/2009
Previous Run	: 34440	Qty:	: 2 Um: Each
Written By	:		
Checked & Approved By	: <u>JULIE DAWSON</u>		
Comment	: Est Rev:A New Issue 06-01-31 JLM est rev B added comment @ # 5.0 06.11.01 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D34763	Dome
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Qty Part Number Description Batch

1 D3476-3 blower motor adapter

B34492

① 10/03/22

2.0	D34767	Tube
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Qty Part Number Description Batch

2 D3476-7 Tube

B47917

B 48210

② 10/03/22

3.0	D34761	Duct
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Qty Part Number Description Batch

1 D3476-1 Duct

B36162

B 56779

② 10/03/22

4.0	NAS1031C3W	Nutplate
-----	------------	----------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Qty Part Number Description Batch

4 NAS-1031C3W Nutplate

1107139

1106574

③ 10/03/22

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spot Weld Tubes And Nut plates as per Dwg D3476 and Dart QSI 018

\*\*\*\*\* D3476-1 goes on top of D3476-3 \*\*\*\*\*

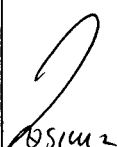
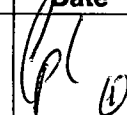
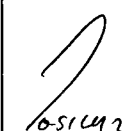
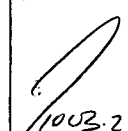
m-l 10/03/24

②X P70

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3476-043 PAR #: \_\_\_\_\_ Fault Category: Small fab. NCR: Yes ☒ No ☐ DQA: 7 Date: 16.03.20  
 Resolution: re-work Disposition: re-work QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>45283</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
16.03.23	5.0	During spot welding on the overlap location, there was a minor blow-out.  B.C. Process		- drill affected area clean, & fill with weld per spec. 4. - grind flush. <u>M111679.</u> - part is non-structural S.S.	 16.03.23	SD 16/03/23		 16.03.23

NOTE: Date & initial all entries

Job Number: 45283

Part Number: D3476043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0



QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 12/03/23

(2)

7.0



QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 10/24/24 (x2)

8.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

9.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

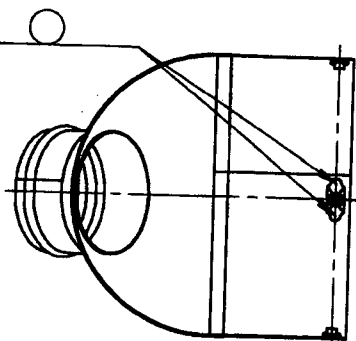
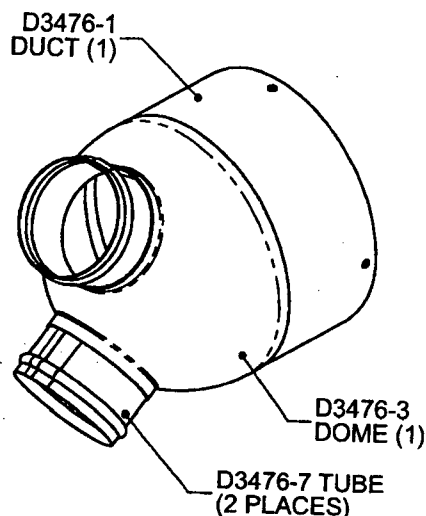
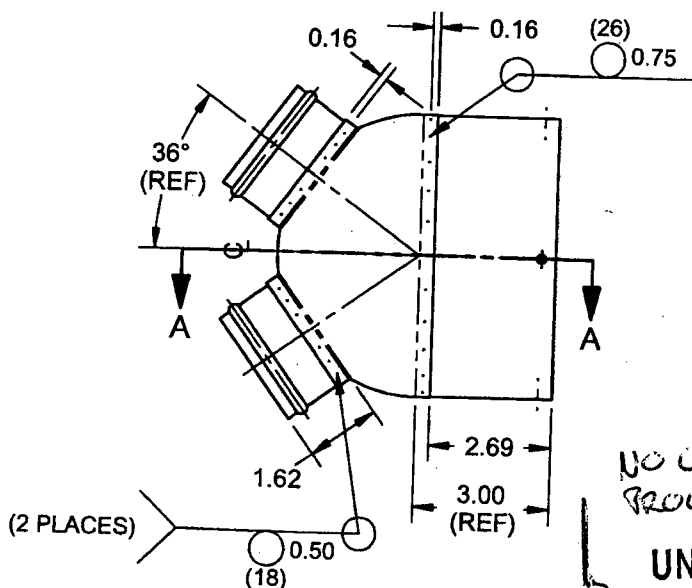
Job Completion



**DART**

DESIGN B	DRAWN BY B	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3476	REV. A
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SHEET 2 OF 7 SCALE 1:4

LOCATE AND  
SPOT WELD  
NUT PLATES  
(4 PLACES)

**SECTION A-A**

NAS-1031C3W  
NUT PLATES  
(4 PLACES)

OFFSET SEAM  
ON DUCT

### **D3476-043 BLOWER MOTOR ADAPTER WELDMENT**

#### **NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) PART IS SYMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -043	P/N	DESCRIPTION
X	D3476-043	BLOWER MOTOR ADAPTER WELDMENT
1	D3476-1	DUCT
1	D3476-3	DOME
2	D3476-7	TUBE
4	NAS1031C3W	NUTPLATE

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# SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 80

EMPLOYEE: Mane Diego 7

PART NUMBER: D3426-043

JOB NUMBER: B 45283-2

MATERIAL TYPE: 304 L

MATERIAL THICKNESS: .018

GROUP SPECIFICATION

☐

Group 1: Aluminum & magnesium

☐

Group 2: Iron; nickel; cobalt

☒

Group 3: Titanium SS

## TEST RESULTS

	PASS	FAIL
VISUAL:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]
PENETRATION:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]
PULL STRENGTH:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]

PSI Reading: \_\_\_\_\_

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 10/03/23

QUALIFIER: SB